

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014735**Date Inspected:** 06-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.An Qing Xiang/Qiu wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed

**IN PROCESS INSPECTION:-**

Trail Assembly Area:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSD1-SA340B/F-14,11 located on Doubler strut plate at 53M elevation.

Welder is identified as 040690. ZPMC QC is identified as Mr.Zhu Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2a-2.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ESD1-SA300B/F-19,22 located on Doubler strut plate at 53M elevation. Welder is identified as 040610. ZPMC QC is identified as Mr.Zhu Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2a-2.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSD1-SA340B/F-15 located on Doubler strut plate at 53M elevation. Welder is identified as 040690. ZPMC QC is identified as Mr.Zhu Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-4213-TC-U4c-1.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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ZPMC performed weld repair after painting. The repair is located on North Shaft Lift 1 Skin C Fit lug at 47.6M elevation. Welder is identified as 057266.ZPMC QC is identified as Mr.Ma Qian Li. SMAW welding was been performed against Temporary weld repair report. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-Repair. Please see the attached picture.

Bay#10:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SPSA5-16-2A located on Lift 5 Interior Splice Plate. Welder is identified as 050289.ZPMC QC is identified as Mr.Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SPSA5-19-2B located on Lift 5 Interior Splice Plate. Welder is identified as 052930.ZPMC QC is identified as Mr.Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:

ZPMC performed Buttering on Lift 5 Grillage plate Skin A stiffeners (SSD1-FCSA5-1).The Buttering area is 5 to 10mm thick. The material is A 709M Grade 485 Non-SPCM. Welders are identified as 040280, 040268.ZPMC QC is identified as Mr. Lu wei chao. SMAW welding was been performed against temporary weld repair report. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-3G(3F)-Repair-1.Please see the attached picture.

Bay#11:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ESD1-SPSA5-7-4A located on Lift 5 Interior Splice Plate. Welder is identified as 041271.ZPMC QC is identified as Mr. Xu Jin long. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

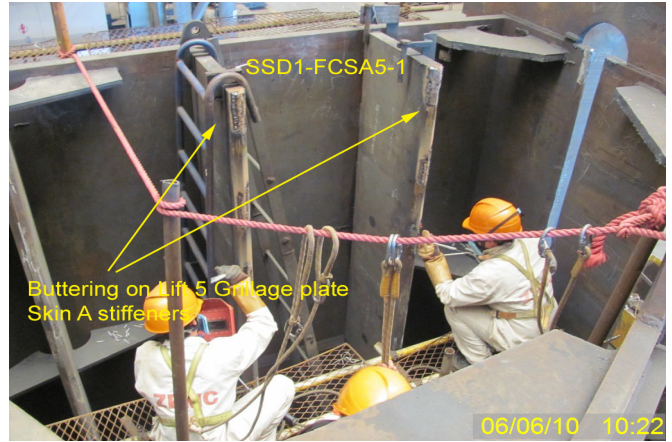
Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## Summary of Conversations:

No Relevant Conversation.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

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**Inspected By:** Pillai,Pandaram

Quality Assurance Inspector

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**Reviewed By:** Clifford,William

QA Reviewer